

Work Order ID 120594

June-05-14 8:21:01 AM

120594

Page 1

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Aft
 Start Date: 6/05/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-06-05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100 0.00 ***100*** Large Fab **DAS 24 9-89**
 Large Fab Memo 0.00
 Large Fab 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
 A/R ER316 S.S. Rod Batch: 122156

110 0.00 ***110*** QC Quality Control **DAS 9 9-89**
 QC Memo 0.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

① 14.06.17 DAS
9-89

1 7/14/14 6:58

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Item ID: D2989-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Lid Aft

Start Date: 6/05/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/05/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	1ST COAT								
	START TIME: 10:05								
	OVEN TEMPERATURE: 400								
	FINISH TIME: 10:35								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89DAS
34
9-89

1x 9 14/06/15

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Item ID: D2989-043 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Basket Lid Aft

Start Date: 6/05/14 Start Qty: 1.00 *1*

Required Date: 6/05/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>WLG</u>	0.00	D356-607-043	13116235		1x	4	90	11/06/14
150	Packaging Memo	0.00							
	Packaging								
160	QC21- Final Inspection - Work Order Release	0.00							
160	QC Memo	0.00							
	Quality Control								

MLJ 14-06-19

14-6-18

Picklist Print

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Work Order ID: 120594

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Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Aft

Start Date: 6/05/14

Required Date: 6/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	9.0000	1	1			
											**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		9							
				100445		7							
				90106		2							
D2989-3 *D2989-3* Rib		Manufactured	No			100	Each	2.0000	1	1			
											**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				97793		1							
				WA004		1							
				88271		1							
D2989-4 *D2989-4* Rib		Manufactured	No			100	Each	2.0000	1	1			
											**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		2							
				97794		2							

14.6/16 DAS
24
9-89
B100 445 → 1

DAS
24
9-89
B 97793 → 1

DAS
24
9-89
B 97794 → 1

Picklist Print

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Work Order ID: 120594

120594

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Aft

Start Date: 6/05/14

Required Date: 6/05/14

Start Qty: 1.00

Required Qty: 1.00

D2989-5

Manufactured No

100

Each

2.0000

2

2

DAS
24
9-89

D2989-5

Rib

**

14.616

389199 → 2

Location

Loc Qty

Loc Code

WA004

2

89199

2

D3182-1

Manufactured No

100

Each

16.0000

2

2

DAS
24
9-89

D3182-1

Hinge

**

388317 → 2

Location

Loc Qty

Loc Code

WA004

16

100864

4

86744

8

88317

4

D3442-3

Manufactured No

100

Each

27.0000

2

2

DAS
24
9-89

D3442-3

Shim

**

388189 → 2

Location

Loc Qty

Loc Code

WA004

27

100273

19

88189

8

D3827-041

Manufactured No

100

Each

3.0000

1

1

DAS
24
9-89

D3827-041

Rib Assembly (Inboard)

**

3 98452 → 1

Location

Loc Qty

Loc Code

WA004

3

98452

3

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Shop Packet Print

Page 2

Picklist Print

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Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Aft

Start Date: 6/05/14

Required Date: 6/05/14

Start Qty: 1.00

Required Qty: 1.00

D3832-5

Manufactured No

100

Each

2.0000

1

1

D3832-5

Mesh (Lid)

DAS
24
9-89

14.6/6
387484 → 1

Location

Loc Qty

Loc Code

WA004

2

87484

2

D3833-5

Manufactured No

100

Each

14.0000

2

2

D3833-5

Mesh (Lid End)

DAS
24
9-89

3101500 → 2

Location

Loc Qty

Loc Code

WA004

14

100771

4

101500

4

96544

2

97022

4

D3838-041

Manufactured No

100

Each

3.0000

1

1

D3838-041

Rib Assembly (Basket Lid, LH)

DAS
24
9-89

387584 → 1

Location

Loc Qty

Loc Code

WA004

3

87584

2

88490

1

D3838-042

Manufactured No

100

Each

3.0000

1

1

D3838-042

Rib Assembly (Basket Lid, RH)

DAS
24
9-89

~~387584~~
387258 → 1

Location

Loc Qty

Loc Code

WA004

3

87258

3

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Shop Packet Print

Page 3

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

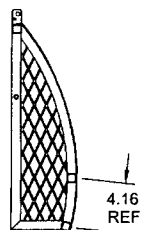
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

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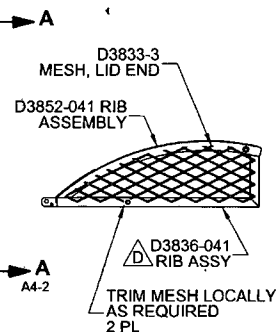
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2, REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG). D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 SHEET 1 OF 5 TITLE BASKET LID ASSEMBLY SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

120594 MLC
14-06-08

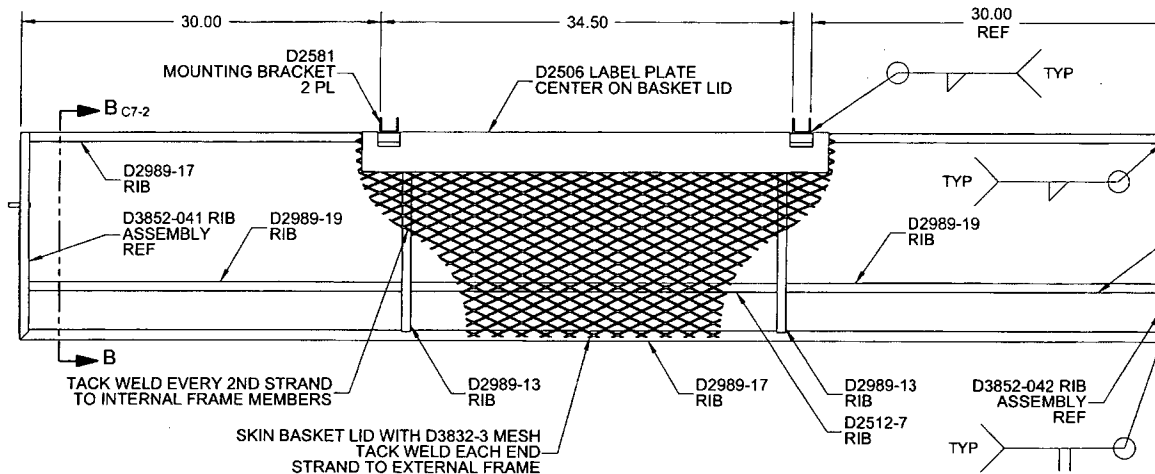
SECTION B-B



D7-2



TRIM MESH LOCALLY AS REQUIRED 2 PL

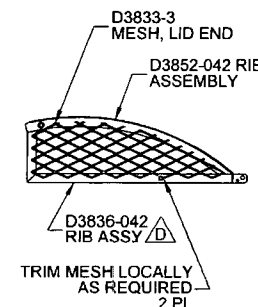
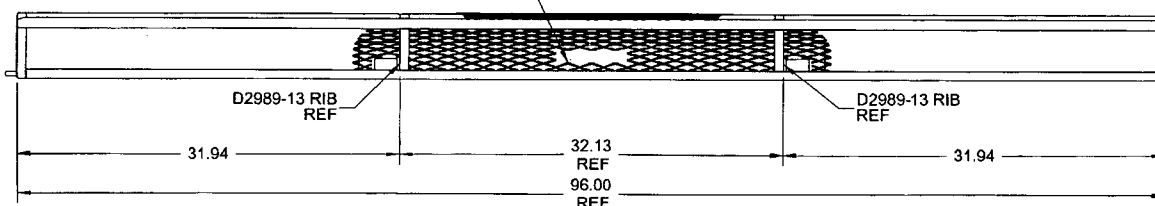


TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID PAINT THIS SECTION

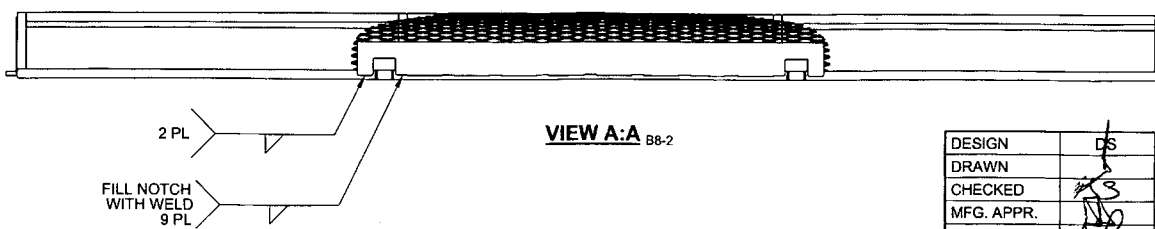
SKIN BASKET LID WITH D3832-3 MESH TACK WELD EACH END STRAND TO EXTERNAL FRAME

TACK WELD MESH TO LABEL PLATE AT EVERY AVAILABLE LOCATION



TRIM MESH LOCALLY AS REQUIRED 2 PL

D2989-041 BASKET LID ASSEMBLY (MESH SHOWN LOCALLY FOR CLARITY)

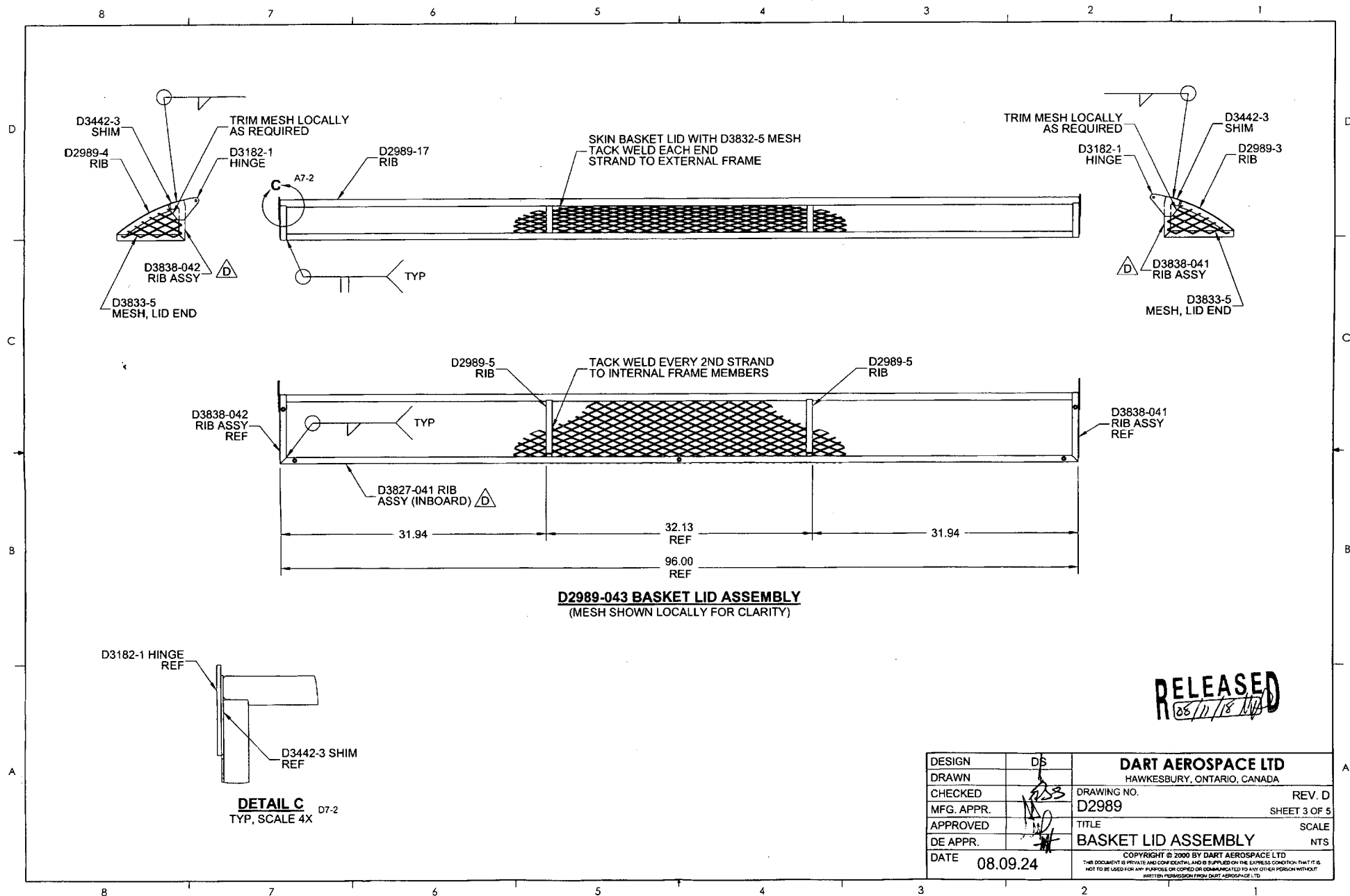


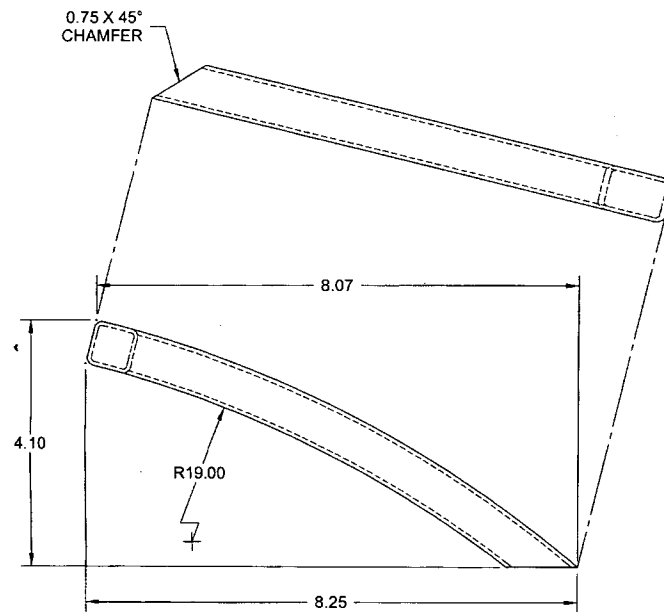
VIEW A-A

B8-2

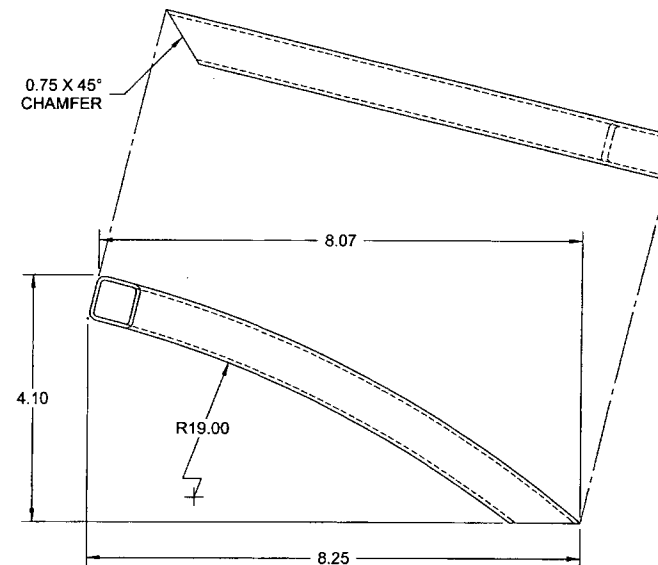
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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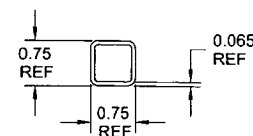


D2989-3 RIB



D2989-4 RIB

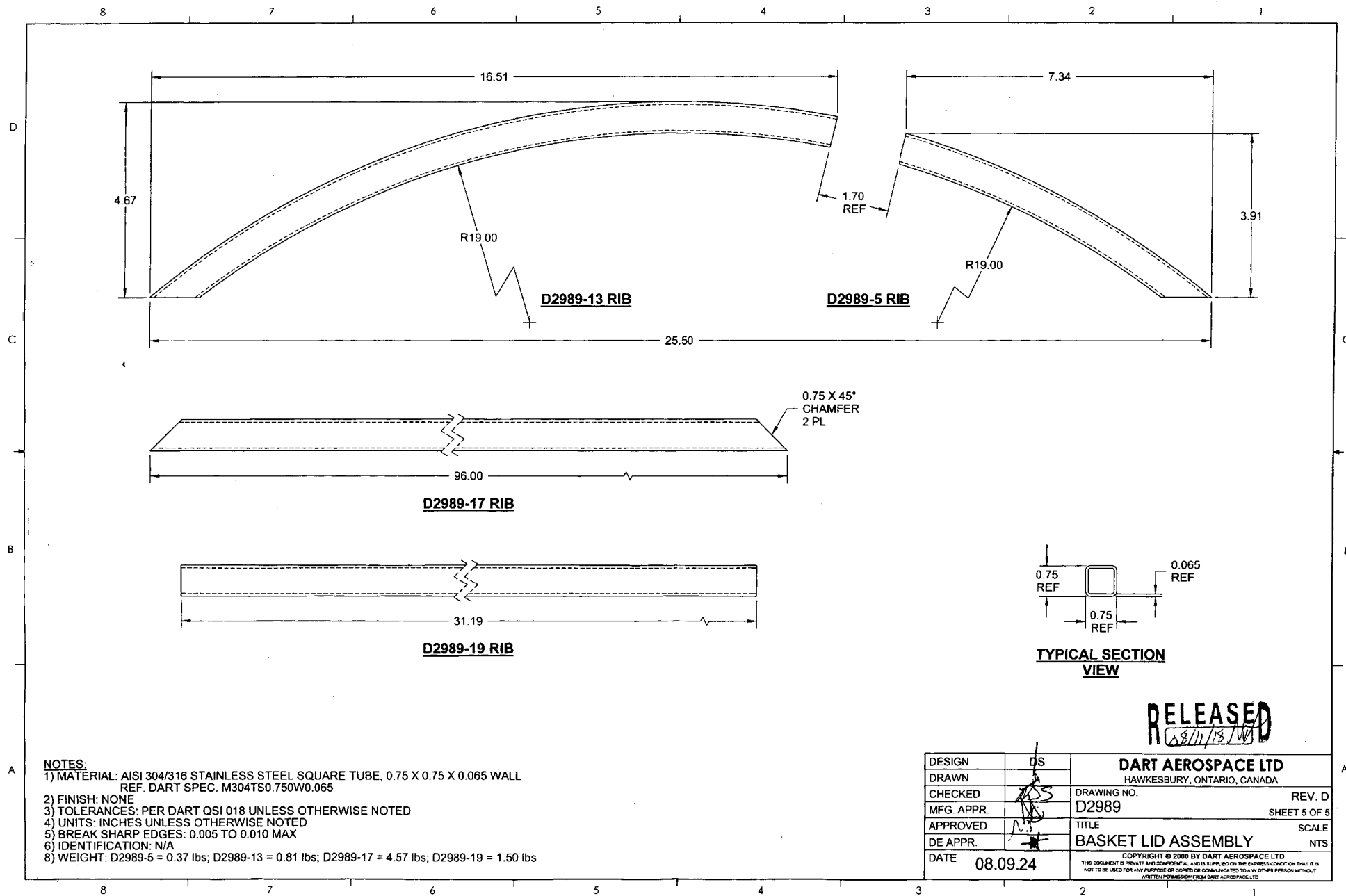
- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION
VIEW**

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08/11/18

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MFG APPR.		D2989	SHEET 5 OF 5
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